

Work Order ID 65341

January 12, 2011 11:44:55 AM



Page 1

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 1/12/11 Start Qty: 4.00



Cust Item ID:

Required Date: 1/26/11 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/01/12 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3272	Rev B

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG002
none eurocopter

11 02 08
CL 11-02-07

110 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R ☐ Aluminum Rod M108436
M115928

3-Grind End Plate flush

11-01-20

4 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				4	0	BE 11/01/21	
130  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				44			
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4614	0		

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Customer:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

H. BR 11-01-24

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

11-01-274 φ

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R ☐ Aluminum Rod M108436

6-Grind End Plate flush

7-Install last rivet as per Dwg.

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



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190 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				4	0	BE 11/2/31	
200 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				44			
210 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4		BR 11-02-31	

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/2/85 (42)

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

M 11 02 08 (4)

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311
Location: 01

Reup

11/2/85 (42)

W/O:		WORK ORDER CHANGES					
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Required Date: 1/26/11 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

wlozlog

MF
11-02-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 65341

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH





Start Date: 1/12/11

Required Date: 1/26/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSI 9410-011  Step Modification		Manufactured	No				Each	2.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG020		2							
				63714		2							
D3272-1  Step		Manufactured	No			110	Each	8.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		8							
				64912		8							
D3067-1  End Plate		Manufactured	No			110	Each	76.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		76							
				63550		76							
D3219-1  Plate		Manufactured	No			110	Each	73.0000	2	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		73							
				63551		73							

B65343

11.01.20

11.01.20

11.01.20

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 65341

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 1/12/11

Required Date: 1/26/11

Start Qty: 4.00

Required Qty: 4.00

✓ D3066-1
Spacer

Manufactured No

180 Each

96.0000

2

8

Location

Loc Qty

Loc Code

WA

96

63549

46

65072

50

8

✓ MS20600-AD4W4

Purchased No

180 Each

2,031.000

16

64

Rivets

Location

Loc Qty

Loc Code

ST321

2031

113368

38

114181

11

114718

2

115573

147

115640

31

116022

302

116188

1500

✓ D3065-041

Manufactured No

180 Each

22.0000

1

4

Step Leg Assembly Hi

Location

Loc Qty

Loc Code

WA

22

63555

22

4

✓ D3067-1

Manufactured No

180 Each

76.0000

1

4

End Plate

Location

Loc Qty

Loc Code

WA

76

63550

76

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 1/12/11

Required Date: 1/26/11

Start Qty: 4.00

Required Qty: 4.00

AN3-35A

Purchased

No

250

Each

168.0000

2

8

Bolt

Location

Loc Qty

Loc Code

ST353

168

116191

100

116419

18

116549

50

D3235-1

Manufactured

No

250

Each

61.0000

2

8

Mounting Lug

Location

Loc Qty

Loc Code

ST471

61

61845

1

63547

60

D3278-041

Manufactured

No

250

Each

8.0000

1

4

Support Assembly

Location

Loc Qty

Loc Code

ST460

8

64731

8

AN960JD416

NAS1149D0463J

Purchased

No

250

Each

30.0000

16

64

Washer

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 1/12/11

Required Date: 1/26/11

Start Qty: 4.00

Required Qty: 4.00

AN960JD516 NAS1149D0563J Purchased

No

250

Each

34.0000

4

16



Washer



1114742 11/2/11

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

Purchased

No

250

Each

151.0000

2

8

AN5-36A



Bolt



11/2/11

Location

Loc Qty

Loc Code

ST341

151

114292

1

116191

100

116549

50

Manufactured

No

250

Each

99.0000

2

8

D2618



Bushing



11/2/11

Location

Loc Qty

Loc Code

ST019

99

63548

36

65071

63

Manufactured

No

250

Each

94.0000

4

16

D2230-3



Lug



1365067 11/2/11

Location

Loc Qty

Loc Code

ST476

94

55452

2

63312

12

64422

80

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 1/12/11

Required Date: 1/26/11

Start Qty: 4.00

Required Qty: 4.00

D2856-400

Manufactured No

250 f

272.5810 1.2 4.8



Abraison Strip



11/2/11

Location

Loc Qty

Loc Code

ST403

272.5810421

56626

0.00004211

59920

56.581

63735

216

7500

*** cut (2) at 7.20" (D2856-400-720) ***

MS21042L3

Purchased No

250 Each

3,264.000 2



Nut



11/2/11

Location

Loc Qty

Loc Code

ST300

3264

114784

9

115835

755

116391

900

116540

800

116549

800

8

AN4-13A

Purchased No

250 Each

179.0000 8



Bolt



1116669 11/2/11

Location

Loc Qty

Loc Code

ST357

179

116191

179

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Required Date: 1/26/11

Start Qty: 4.00

Required Qty: 4.00

MS21042L5

Purchased

No

250

Each

1,353.000

2

8



Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1327

115156

5

115594

500

116104

126

116105

496

116548

200

MS21042L4

Purchased

No

250

Each

4,788.000

8

32



Nut

Location

Loc Qty

Loc Code

ST300

4788

1123143

2

115589

10

115621

276

116188

3500

116548

1000

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

8.0000

4

16



Washer

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART

DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED*07.06.04*

B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65341

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

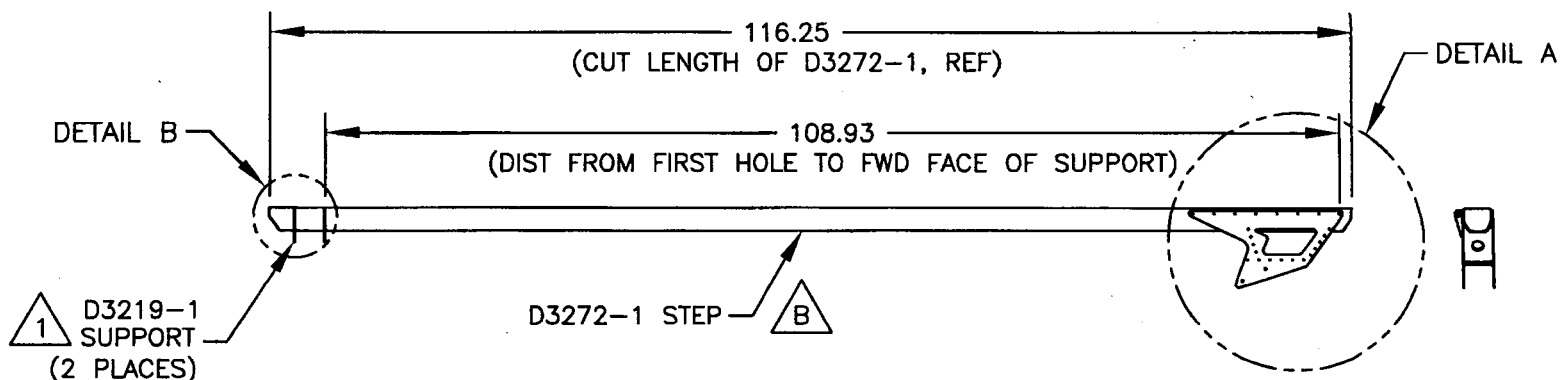
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DART



D3272-041 STEP ASSEMBLY (LH. SHOWN)

D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

SHOP COPY

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 65341

APPLY BLACK ANTI-SKID
ON TOP SURFACE TO
BOTTOM OF TOP RADIUS

RIVET D3065-041
TO D3272-1 USING
MS20600AD4W4 RIVET
(16 PLACES)

GRIND FLUSH
(TYP)

3.375
(TYP)

D3219-1
SUPPORT
(REF)

D3067-1 END PLATE
(2 PLACES)

DETAIL B
(SCALE 1:5)

D3066-1 SPACER
(2 PLACES)

D3065-041
LEG ASSEMBLY

DETAIL A
(SCALE 1:5)

1.36
(REF)

0.65
(REF)

RELEASED
07.05.18

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED <i>CE</i>	DRAWING NO. D3272
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG	REV. B SHEET 2 OF 3 SCALE 1:20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

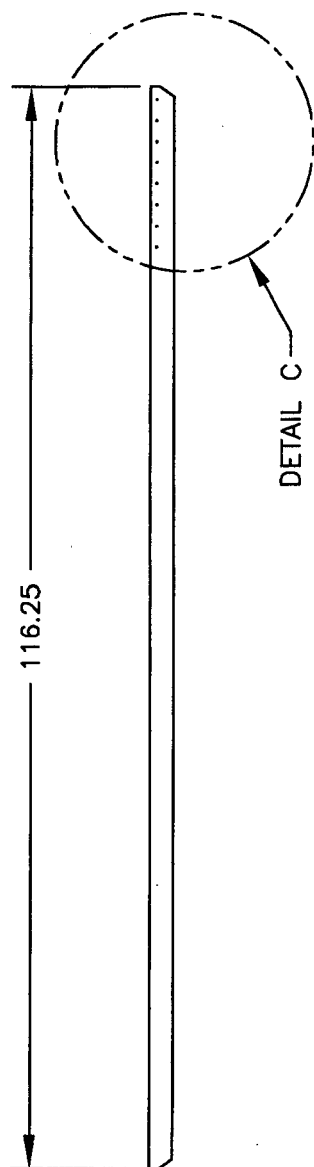
NOTE: Date & initial all entries



DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

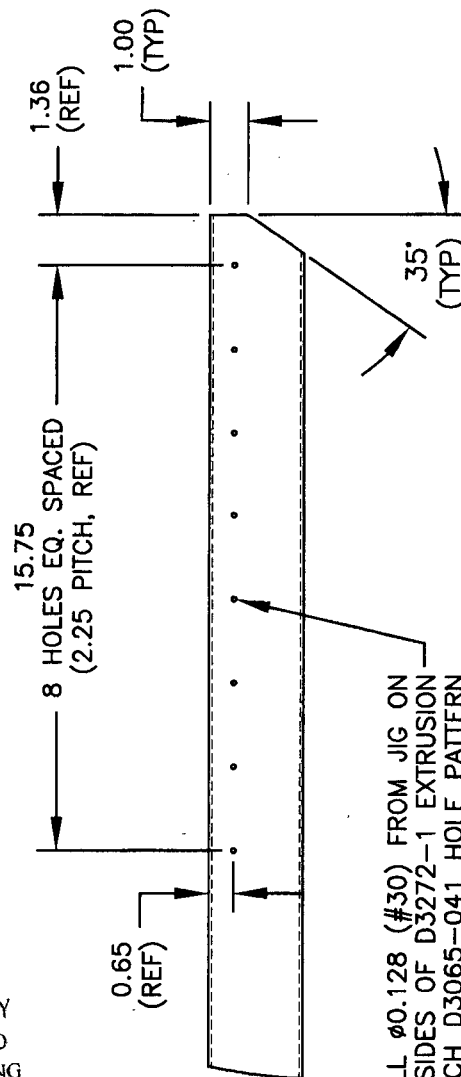
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65341

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD.

D350-591
Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.